

Work Order ID 86446

June-29-12 7:44:07 AM

86446

Page 1

Item ID: D2926-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Web

Start Date: 29/06/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/29*

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2926	Rev A								
100		0.00							
100	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Cut D2500-3 to length: 98.44"								
	2- Drill pilot holes and open to size using drill Jig DT8777 as per Dwg D2926								
	3- Deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

(3) SAD 12-07-03

3 0 BE 12-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 3.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.00				3			7/6/12-74
Hand Finishing									
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									

③ SAD 12-07-04

③ SAD 12-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Accept

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Stop ***NS2***

Item Name: Web

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Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/7/4

1/20/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-29-12 7:44:11 AM

Work Order ID: 86446

Parent Item: D2926-3

Parent Item Name: Web

86446

D2926-3

Page 1

Start Date: 29/06/2012

Required Date: 06/07/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP B05.05.25 Added drill Jig to step 3; 98.44"" was 89.44""KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	88.0000	1	3			

D2500-3-100

Ext'n - I' Beam Web 4"

**

[Handwritten signature]

[Handwritten signature]

12-07-03

Location

Loc Qty

Loc Code

LG

88

51957

2

79041

2

84873

84

[Handwritten circle with number 3]

Dart Aerospace Ltd

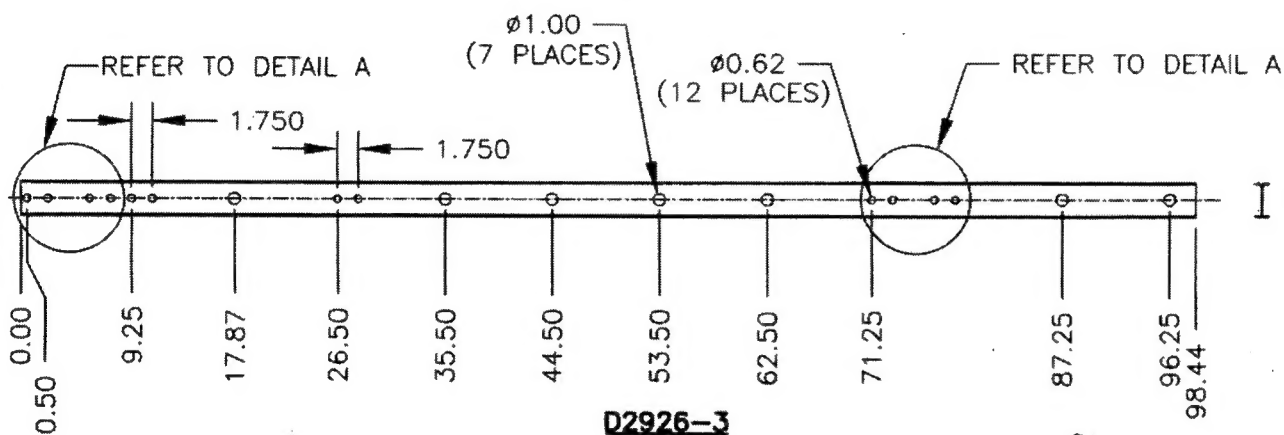
W/O:		WORK ORDER CHANGES					
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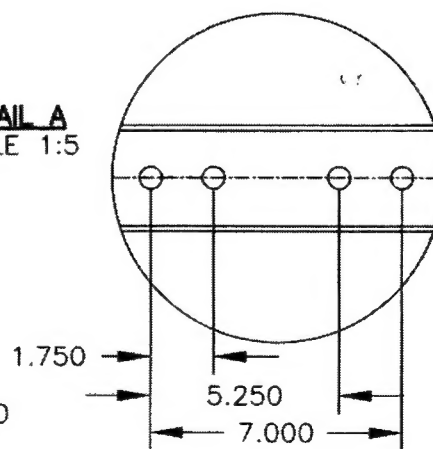
NOTE: Date & initial all entries

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RELEASED
04-06-25

DETAIL A
SCALE 1:5



GENERAL NOTES:

- 1) MAKE FROM D2500-3 EXTRUSION
- 2) ALL HOLES ON CENTERLINE
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

QA CONTROL ISSUED

DESIGN	DRAWING BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. A
CHECKED	APPROVED		DRAWING NO.
DATE		TITLE	SHEET 1 OF 1
04.06.22		WEB	SCALE 1:15
A	04.06.22	NEW ISSUE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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